

Date: Friday, 29/08/2008 1:30:26 PM
 *User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|----------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | FLOAT SKIDTUBE |
| Job Number : | 41686 | Part Number : | D412742013 |
| Estimate Number : | 10366 | Drawing Number : | N/A |
| P.O. Number : | | Project Number : | N/A |
| This Issue : | 29/08/2008 | Drawing Revision : | D |
| Prsht Rev. : | NC | Material : | |
| First Issue : | 29/08/2008 | Due Date : | 10/09/2008 |
| Previous Run : | 41685 | Qty: | 1 Um: Each |
| Written By : | | | |
| Checked & Approved By : | <u>JLD 08.8.29</u> | | |
| Comment : | Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Hg for JLD 08.9.11



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013

CHC7005

CHC004

50511105

| | | |
|-----|--------|---------------------|
| 2.0 | 41686A | FLOAT SKID ASSEMBLY |
|-----|--------|---------------------|



Comment: Sub-Component FLOAT SKID ASSEMBLY

1 x D412-742-043

Batch

41686A SD

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|-------|---------------------|
| 4.0 | D2571 | Saddle, Fwd Out 205 |
|-----|-------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2571 Saddle Fwd Outside

B41587

SC

| | | |
|-----|-------|--------------------|
| 5.0 | D2572 | Saddle, Fwd In 205 |
|-----|-------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2572 Saddle Fwd Inside

B40515

8/11/21

SD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: FLOAT SKIDTUBE

Job Number: 41686

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2573 Saddle Aft Outside B40516

SP

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2574 Saddle Aft Outside B41590

SP

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2876 Saddle Spacer B38662

SP

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2877 Saddle Spacer B39125

SP

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D3403-1 Bushing B41709

SP

11.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2747 Bolt B39221

glulax

SP

| W/O: | | WORK ORDER CHANGES | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41686

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D35331

Set Screw



B341606



50

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Set Screw

13.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

M107242

30

14.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

M165423

50

15.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

M104289

50

16.0

D36723

Phenolic Washer



B341775



50

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

PHENOLIC WASHER

17.0

AN960C416L

WASHER



M169220



50

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

18.0

D36729

Phenolic Washer



B35523



(1x)

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

8/11/21

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41686

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C616L

WASHER



M108672



SP

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

20.0

D367211

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER

B35524

SP

21.0

MS210434

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Nut

M109165

SP

22.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M108119

SP

23.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 D3403-3 Bushing A 40528

SP

24.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-041 GHW Lug M335779

SP

25.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-043 GHW Lug M334841

8/11/21

SP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: FLOAT SKIDTUBE

Job Number: 41686

Part Number: D412742013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
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|------|---------|------|
| 26.0 | AN4C46A | BOLT |
|------|---------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 4 | AN4C46A | Bolt | M107467 |

sq

| | | |
|------|----------|-----|
| 27.0 | MS210434 | Nut |
|------|----------|-----|



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|---------|
| 29 | MS21043-4Nut | | M109165 |

sq

| | | |
|------|----------|----------|
| 28.0 | D3407041 | Tow Ring |
|------|----------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3407-041 | TOW RING | 340529 |

sq

| | | |
|------|--------|--------|
| 29.0 | D34173 | Washer |
|------|--------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | D3417-3 | WASHER | 1339732 |

sq

| | | |
|------|--------|--------|
| 30.0 | D34561 | Washer |
|------|--------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | D3456-1 | WASHER | 1340285 |

sq

| | | |
|------|---------|------|
| 31.0 | AN3C37A | BOLT |
|------|---------|------|



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

M106069

6/11/21

sq

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41686

Part Number: D412742013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------|------|
| 32.0 | AN3C40A | BOLT |
|------|---------|------|



M106169



50

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

| | | |
|------|---------|------|
| 33.0 | AN3C41A | BOLT |
|------|---------|------|



M108084



50

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

| | | |
|------|---------|------|
| 34.0 | AN3C42A | BOLT |
|------|---------|------|



M106169



50

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

| | | |
|------|---------|------|
| 35.0 | AN3C43A | BOLT |
|------|---------|------|



(3) M106227 (1) M106228



50

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT

| | | |
|------|---------|------|
| 36.0 | AN3C46A | BOLT |
|------|---------|------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOLT

M106169

50

| | | |
|------|-----------|--------|
| 37.0 | AN960C10L | washer |
|------|-----------|--------|



1x

Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
washer

M109174

50

| | | |
|------|----------|-----|
| 38.0 | MS210433 | Nut |
|------|----------|-----|



~~M108880~~



(1x)

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut

8/11/20 M108672 50

| | | |
|------|-----|------------------------------------|
| 39.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/05/25 (+0)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41686

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



ⓧ

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: 73

Rev 9

8/11/25

SD

41.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



muf 08-11-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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